

Work Order ID 117863

117863

Page 1

May-23-14 10:25:41 AM

Item ID: D2916-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cable Guard, 212 Skidtube

Start Date: 5/05/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2916

Rev D

102

0.00

102

Purchasing

Memo

0.00

Purchasing

ISSUE PO

24350

1-Cut as per Dwg D2916

Dwg Rev:

Prog Rev:

2-

Deburr if necessary

CZ 14/05/26 8

105

Receive & Inspect for Damage & Mat'l Certs

0.00

105

Packaging

Memo

0.00

Packaging

8x 8p14-6-10.

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

CZ 14/08/21

8 0

May-23-14 10:25:41 AM

Item ID: D2916-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cable Guard, 212 Skidtube

Stop *NS2*

Start Date: 5/05/14 **Start Qty:** 8.00

g

Cust Item ID:

Required Date: 5/05/14 **Req'd Qty:** 8.00

8

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

BATCH: _____ 1- Mill as per Folio FB077 Rev: AA
& Dwg D2916 Rev: D 2-Deburr per dwg D2916

7 0 DAS 20 14-08-23
9-88

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

Quality Control

7 *0* **DAS**
20
9.89 14-08-23

140

QC8- Inspect parts - second check

0.00

140

OC

Memo

Quality Control

7 2

DAS
37
9-89 14 00 3

Work Order ID 117863***117863***

Page 3

May-23-14 10:25:41 AM

Item ID: D2916-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cable Guard, 212 Skidtube

Start Date: 5/05/14

Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/05/14

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 51187

0.00

150

Packaging

Memo

0.00

Packaging

7x

DAS
28
9-89

AUG 25 2014

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS 14-08-25

APR 8 25

Picklist Print

May-23-14 10:25:40 AM

Page 1

Work Order ID: 117863

117863

Parent Item: D2916-3

D2916-3

Parent Item Name: Cable Guard, 212 Skidtube

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-19 JLM
IPP Rev:B Now water jet 06-07-14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	400.0000	0.55	5			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

CL 4/05/28

Location

Loc Qty

Loc Code

MAT018

400

m128267

47

m128668

353

m129293

DART AEROSPACE LTD		Work Order:	117863
Description: Cable Guard		Part Number:	D2916-3
Inspection Dwg: D2916	Rev: D		Page 1 of 1

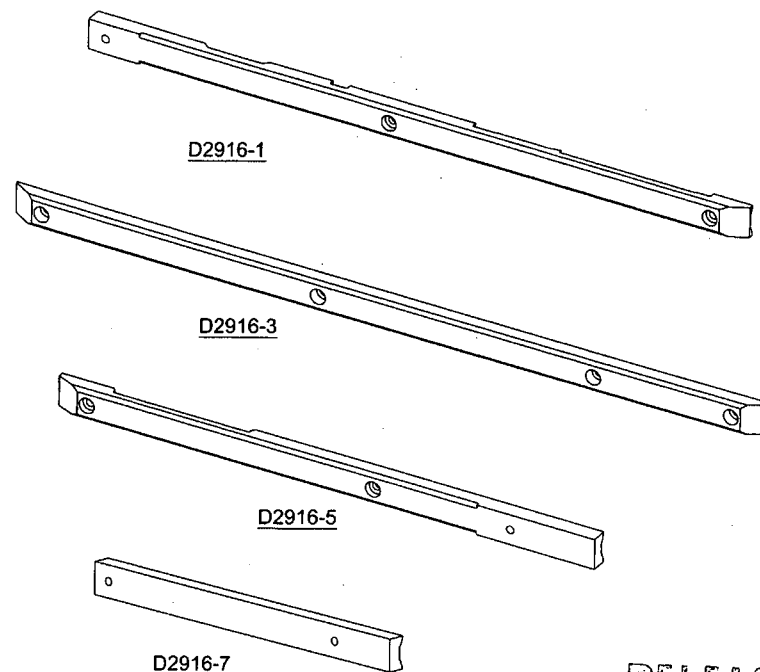
FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

DAS		DAS			
Measured by:	20 9-89	Audited by:	37 9-89	Preliminary Approval:	
Date:	14-08-23	Date:	14-08-24	Date:	

Rev	Date	Change		Revised by	Approved
A	04.01.12	New Issue	P/O D205-665-015	KJ/RF	
B	12.07.31	Dwg Rev updated		KJ	

117863 MJS
14-05-06








NOTES:

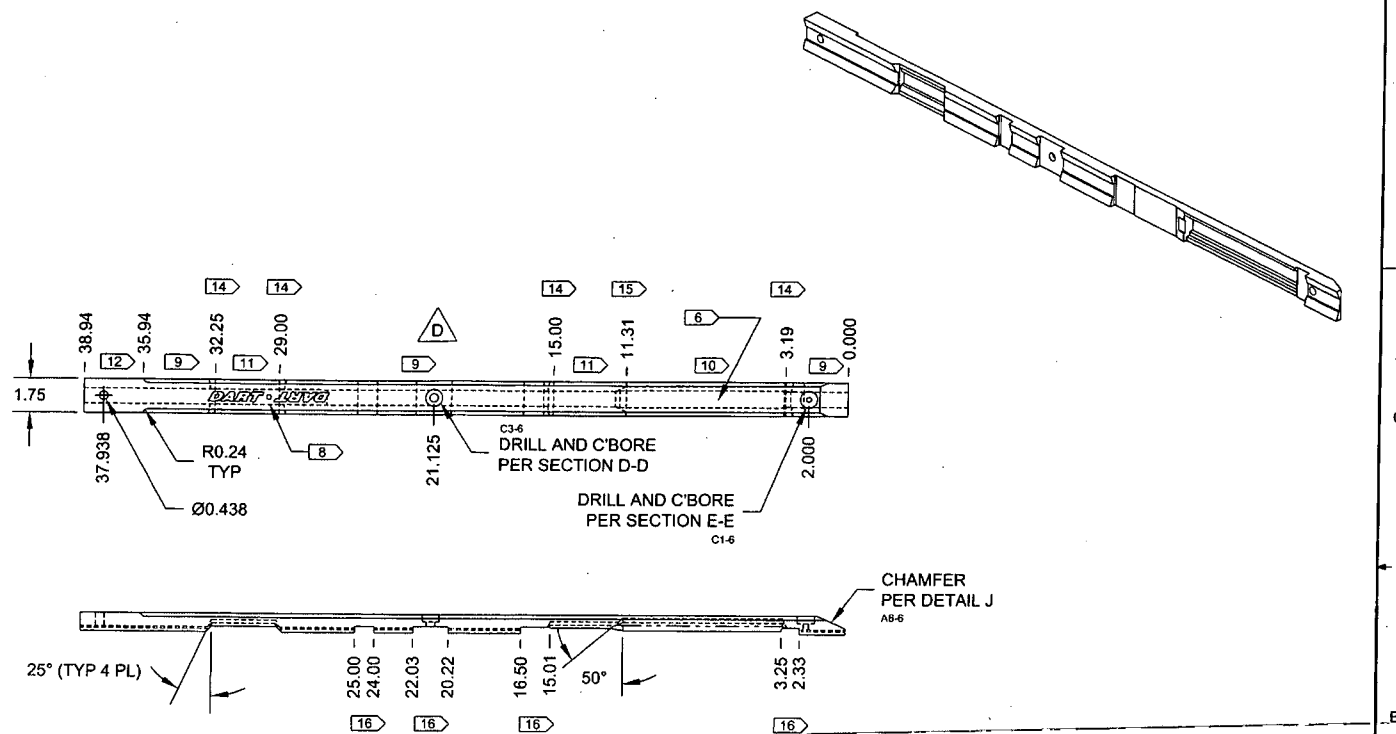
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 6) IDENTIFICATION: ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010
- 7) WEIGHT:

D2916-1 = 1.37 lbs
D2916-3 = 2.33 lbs
D2916-5 = 1.19 lbs
D2916-7 = 0.96 lbs

- 8) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250
- 9) MACHINE CONSTANT SECTION A-A
- 10) MACHINE CONSTANT SECTION B-B
- 11) MACHINE CONSTANT SECTION C-C
- 12) MACHINE CONSTANT SECTION F-F
- 13) MACHINE CONSTANT SECTION G-G
- 14) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 15) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 16) MACHINE SLOT WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 17) ALL HOLES DRILLED ON CENTERLINES

RELEASED
2011-11-02
JMP

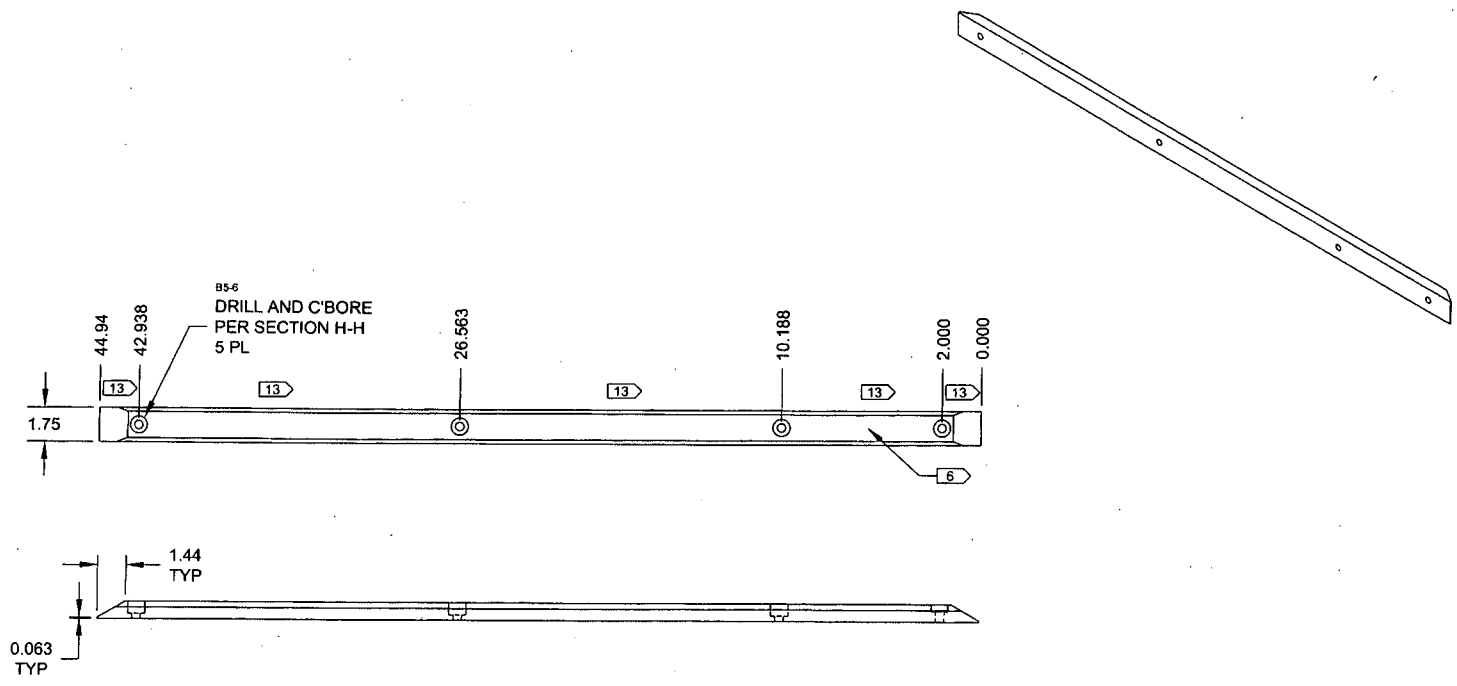
D	REVISE MACHINE SLOT. (ZN C5-2, C4-4, C4-5, C6-5) REVISE SECTIONS D-D, L-L, N-N		RF	11.10.07
C	REVISE D-D; ADD L-L, M-M & N-N; FOR D4406-041/-043 COMPATIBILITY		RF	11.08.17
B	ADD K-K FOR D2521 COMPATIBILITY		CP	00.02.24
A	NEW ISSUE		CP	99.09.29
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED			DRAWING NO.	REV.
MFG. APPR.			D2916	SHEET 1 OF 6
APPROVED			TITLE	SCALE
DE APPR.			CABLE GUARD	NT
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D2916-1

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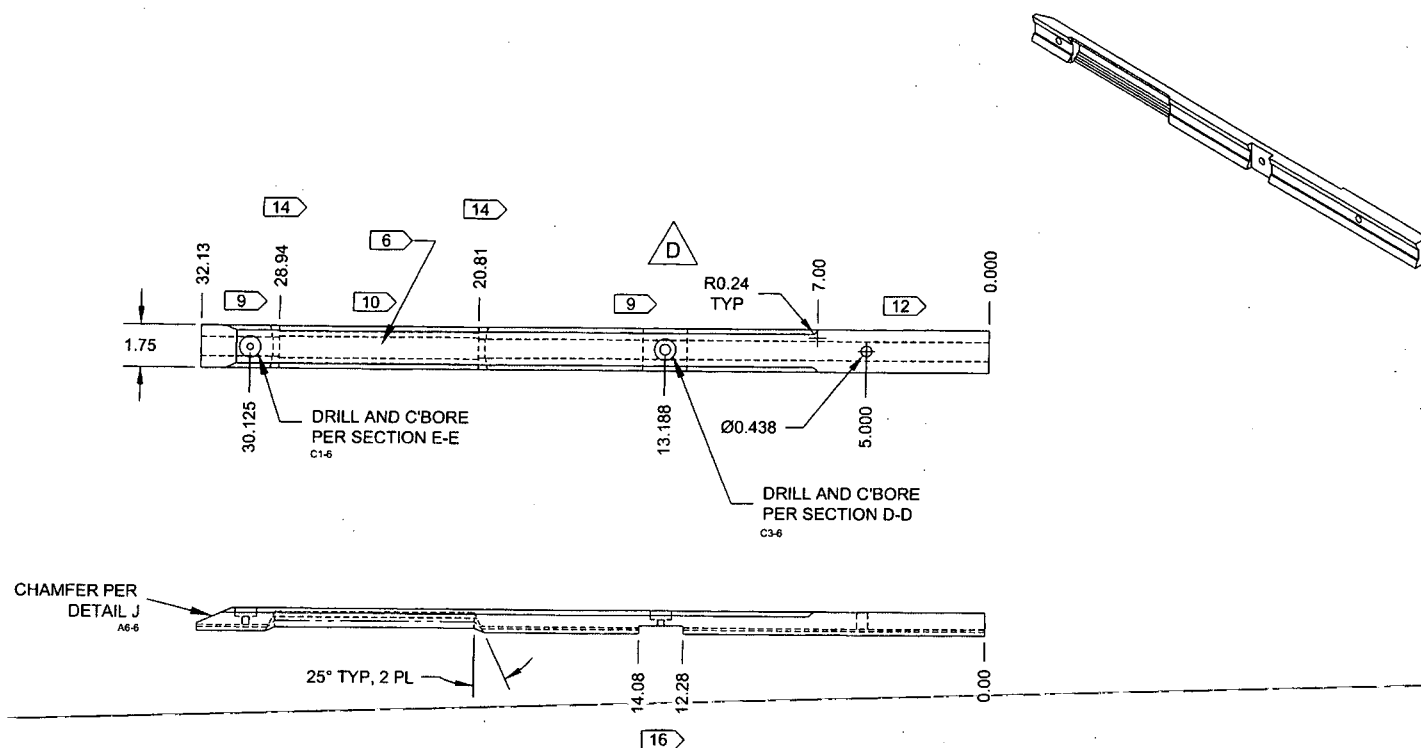
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D2916-3

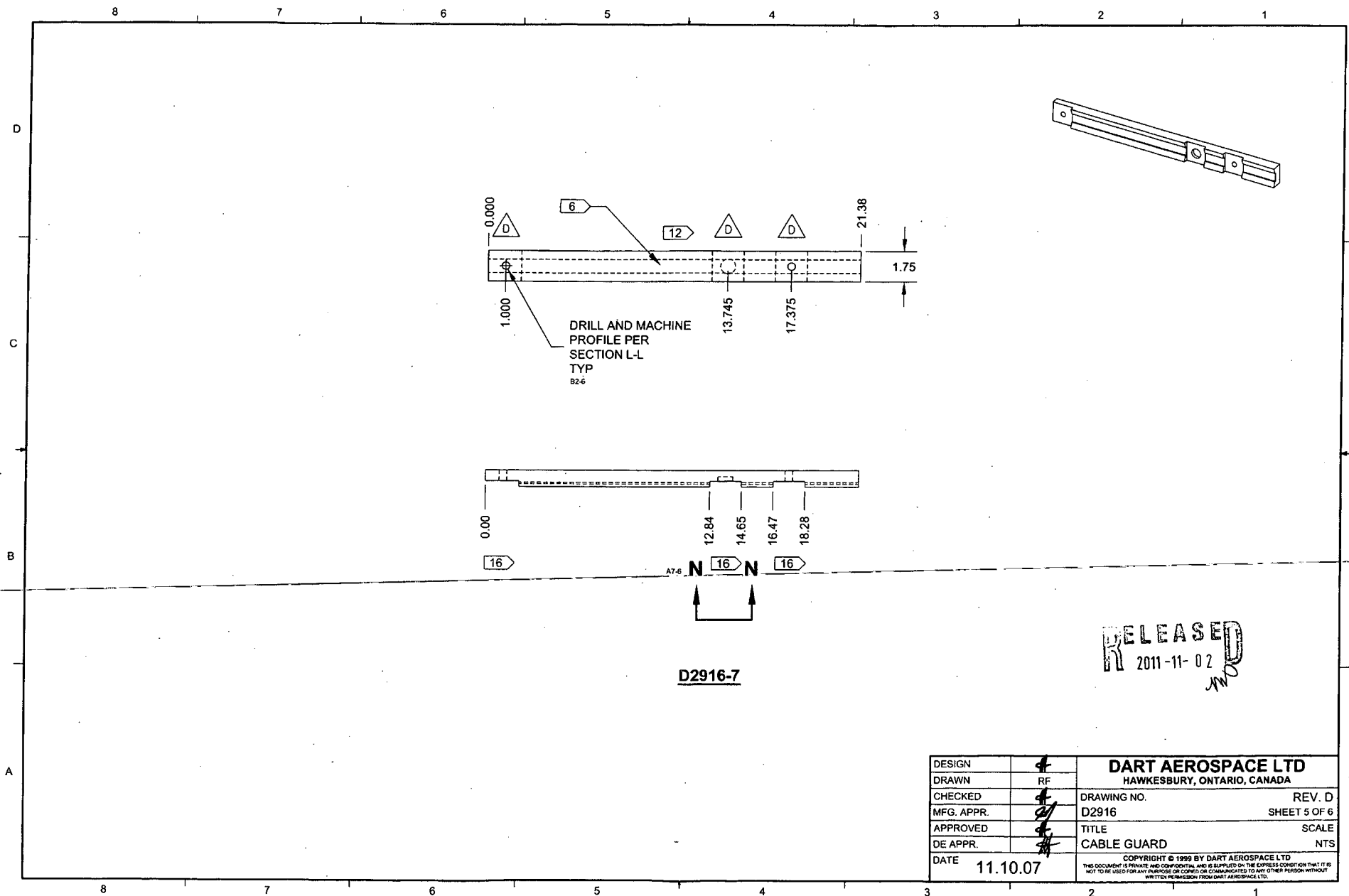
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MFG. APPR.	4		
APPROVED	4		
DE APPR.	4	DATE 11.10.07	

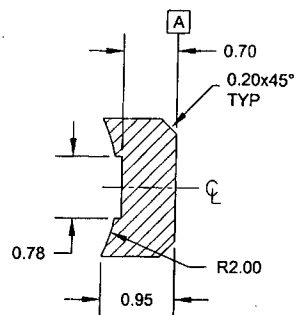


D2916-5

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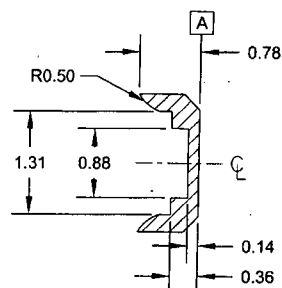


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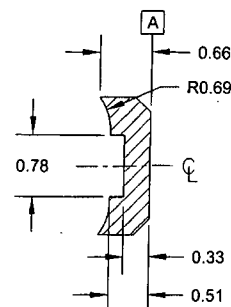
SECTION A-A
SCALE 4X

C3-2
C6-2
C4-4
C6-4



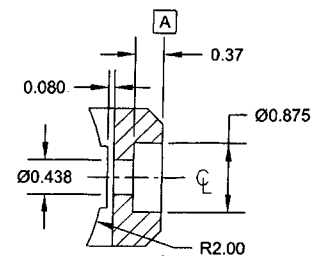
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SCALE 4X

C3-2
C5-4



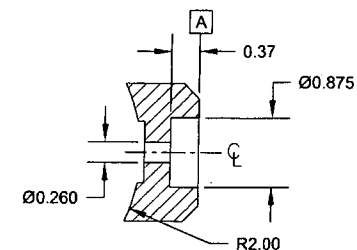
SECTION C-C
SCALE 4X

C5-2
C4-2



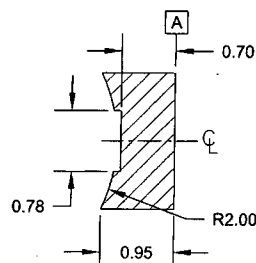
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SCALE 4X

C4-2
C3-4



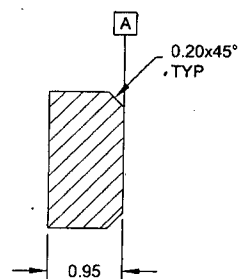
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SCALE 4X

C3-2
C5-4



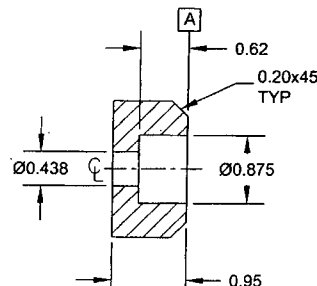
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C6-2
C3-4
C5-5



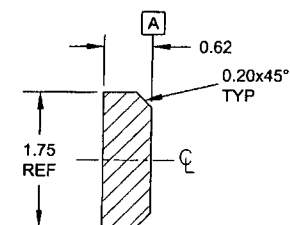
SECTION G-G
SCALE 4X

C3-3
C4-3
C5-3
C6-3
C7-3



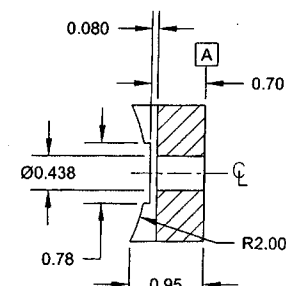
SECTION H-H
SCALE 4X

C6-3



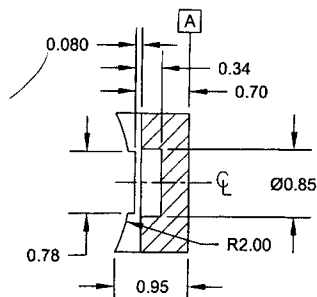
SECTION K-K
SCALE 4X

B3-2
B4-2
B5-2



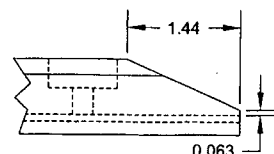
SECTION L-L
SCALE 4X

C5-5



SECTION N-N
SCALE 4X

B6-5



DETAIL J
SCALE 4X

B3-2
B7-4

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2011-11-02

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24350**

Purchase Order Date 5/26/2014

PO Print Date 5/26/2014

Page Number 3 of 4

Order From :

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

VC-TPI001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via: Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

7	117863	D2916-3 CABLE GUARD	6/13/2014 Yes 6/13/2014	8.00	✓	\$24.80	\$198.	
							Line Total:	\$198.
8	117834	D3049-1 BEARPAW	6/13/2014 Yes 6/13/2014	12.00	✓	\$33.30	\$399.	
							Line Total:	\$399.
9	116954	D3075-1 BEARPAW	6/13/2014 Yes 6/13/2014	12.00	✓	\$18.37	\$220.	
							Line Total:	\$220.

SP14-6-10

Note:

5/26/2014